Work Order I Wednesday, May 26,		,				-				Page 1	=:
Item ID: D35 Revision ID: Item Name: Sado	500-1	,	Accept .		11/// 1/11// 11/// // // // // // // //		Setup	Start Stop		 	
Start Date: 5/26 Required Date: 6/4/2 Reference:	5/2010 Start Qty: 8.00 2010 Req'd Qty: 8.00	1 2000 A 1011 A 1011 1 1000 A 1011 A 1011		Cust Item II Customer:	<b>D</b> :	-	1	Stop		1818 118 1181 1881	•
Approvals: Pro	ocess Plan:	Date: <u>16526</u>	Tooling: SPC (Y/N):	•	te:	ļ		Start Stop			
Sequence ID/ Work Center ID Draw Nbr	Operation Description Revision Nbr	-	Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reje Qty		eject umber	Insp. Stamp	
HAAS 1 HAAS CNC vertical maching the state of the state o	HAAS CNC VERTICAL  Memo  ine #1 Program Ba  per Folio FA  No 2 per Fol	ch No. S//2Double che 641 and inspect per attached in FA641 and inspect per attached in Folio FA641 and inspect pachine FAI/FAIB	Dimension Sheets □2-	chine Step No Machine Step 10. C	23	8					-
QC _ Quality Control	Memo	, ,	0.00	- wine ix		8		7			

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Dart Aer	Uspace	: Lta						1		τ
W/O:			V	ORK OR	DER CHANGE	ES				
DATE	STEP	PROC	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
•		<u>'</u>			*#					
-										
ļ			. •							
								<u> </u>	1	
Part No:	D35	500-   PAR #:	Fault Ca	tegory: <u>w</u> A	chining	NCR: Yes	No DQA:	/	Date: _	1007.09
		esolution: <u>Scrap</u>			<b>₹</b>		osed:	/		<del>50709</del>
NCR:50	1120	/ We	ORK OR	DER NON	-CONFORMA	NCE (NCF	R)	/		
DATE	STEP	Description of NC Section A	Initial	Corrective Actio	n Description	Sign 8	Verifica Section		Approval Chief Eng	Approval
,o. b. 2 <sup>2</sup> 7	100	WISTAKEN OFFET VALUE INPUT. CUTTING TOOL TOO LONG WRECKIN THE WORKPIECE BEYOND REPAIR	Chief Eng Flux vb.75	SORAP OHY +1	Chief Eng  2 Sp LACE  B 41962	Date	39 5		90 06.23 05/042	Sololo
		LL-Operate error								
			,							7%
				;						**

Work Ord Wednesday, Mag												Page 2
Item ID: Revision ID: Item Name:	D3500-1 Saddle	•		Accept					Setup	Start Stop		HARA IA HALIAN Hara ia kalian
Start Date: Required Date: Reference:	5/26/2010 6/4/2010	Start Qty: 8.00 Req'd Qty: 8.00	18818  1811 1881   18818  1811 1881		Cust Iter Custome		,			-		
Approvals:	Process Pla	an: Date:		Tooling:		Date:	1		Run	Start		
	QC:	Date:		_ SPC (Y/N):		Date:	-			Stop		
Sequence ID/ Work Center ID  130 HandFinish Hand Finishing	•	Operation Description Chemical Conversion Coat per QSI  Memo	005 4.1	Set Up/ Run Hours 0.00	Tool ID		Plan Code	Accept Qty	t Reje Qty		Reject Number	Insp. Stamp
140  Powdercoat  Powder Coating		White Gloss(Ref:4.3.5.1) per QSI00  Memo  START TIME:  FINISH	1841 18:45	0.00 0.00 □OVEN TEMPERATUR	E:		8	bl	·	10~	6-6	>5
50		QC3- Inspect Part Finish		0.00				٨		•		
QC Quality Control		Memo		0.00		ď		MI			04	25 (8

## Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr QC Inspector Approval OC Inspector

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	 Date:
Resolution:		Disposition:	QA: N/C Closed:	 Date:

NCR:		WORK ORDI	ER NON-CONFORMAN	CE (NCR)			
	Description of NC		Corrective Action Section B		Varification	Annewal	Annuoval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
						‡	
	AV-100						
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section B Section A Initial Action Description	STEP Description of NC Corrective Action Section B  Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Corrective Action Section B Verification Approval Section A Section C Chief Eng

W	ork	O	rder	ID	591	20
	~	~				~

Wednesday, May 26, 2010 1:25:15 PM



Page 3

Item ID:

D3500-1

Accept

Tool # Plan

Code

Setup Start

Stop

**Revision ID:** 

Item Name:

Saddle

**Start Date:** 5/26/2010 Required Date: 6/4/2010

Start Qty: 8.00

Req'd Qty: 8.00

Cust Item ID:

**Tool ID** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_

QC:

Date:\_\_\_\_\_

Tooling:

SPC (Y/N):

Date: Date:

Run

Number Stamp

Insp.

Stop

Reject

Qty

Start

Sequence ID/ Work Center ID

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours** 

0.00

0.00

10-6-25

Accept

Qty

Reject

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

10/06/28 9 CX10/6/25

Dart Aerospace L	∟td
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W/O:			V	VORK ORDER CHA	NGES					
DATE	STEP	PRO	CEDURE CH	HANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			-							
		·								
Part No	•	PAR #:	Fault Ca	tegory:	NCR	: Yes 1	lo DQA:		Date:	
	R	esolution:	Disposit	ion:	QA:	N/C Clo	sed:		Date:	
NCR:		V	VORK OR	DER NON-CONFOR	RMANCE	(NCR)				
DATE	STEP	Description of NC	Initial	Corrective Action Action Description	Section B	Sign &	Verifica		Approval	Approval
		Section A	Chief Eng	Chief Eng		Date	Section	С	Chief Eng	QC Inspector

## **Picklist Print**

Wednesday, May 26, 2010 1:25:20 PM

Work Order ID: 59120

Parent Item: D3500-1

Parent Item Name: Saddle

Comments:

IPP Rev:A New Issue 06-06-15 JLM

**Start Date:** 5/26/2010

Start Qty: 8.00

Required Date: 6/4/2010

Required Qty: 8.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Manufactured

Bin Primary Item Location

No

Last Location

Route Seq ID

100

Unit of Measure

Qty on Hand

1.0000

Qty per Kit Total Qty

8

Qty Issued Date Status Issued

Page 1

D6102-013

Saddle Billet

Location

MAT43

Loc Qty

Each

Loc Code

Dart	Aerospace	Ltd

W/O:			V	VORK ORDER CHANG	ES		1		
DATE	STEP	PROC	EDURE CH	HANGE	Ву	Date C	ty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								;	
	[					,			
Part No:	<b>.</b>	PAR #:	Fault Ca	tegory:	_ NCR: Yes I	No DQA:		_ Date: _	
	R	esolution:							
NCR:		W(	ORK OR	DER NON-CONFORMA	NCE (NCR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Secti Action Description Chief Eng	on B Sign & Date	Verificat Section		Approval Chief Eng	Approval QC Inspector
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		For .		*					,
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DART AEROSPACE LTD	Work Order:	59120
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of A

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
<u> </u>	0.483	0.490		,485	485	100	100		
В	1.175	1.185		1.180	1.180	1485			
С	3.145	3.155		3-150	3-150	1.180	1.180	<del>   </del>	
D	1.175	1.185		1.180	1/80				
E	0.365	0.385		-228	- 375				
F	0.490	0.510		566	· 500	- 375	- 375		
Н				-	, 200	. 500	.500		
1	R1.575	R1.595		1-590	1,590		1 600		
J	0.240	0.260		1245	2/15	1.590	1.880		
K	0.490	0.510		,502	1245	-245	-245		
_ <u>L</u>	3.590	3.650		3.625	502	- 502	-502		
M	0.315	0.322		.320	3.625	3.625	3.625		
N	0.256	0.262		-250	.320	. 320	.320		
0	6.500	6.520		6.50		.258	.258		
Ρ	5.990	6.010		4.660	6.510	6.510	6.510		
Q	2.820	2.830		2.823	6.000	6.000	6.000		
R	2.495	2.505		2.498	2.823				
S	2.245	2.255		2.250	2.488	2,498	2.498		
T	1.120	1.130		1.125	2.250	2.250	2.250		
U	0.540	0.560		==45	1-125	1.125	1.125		
V	0.793	0.803		.798	- 545	. 545	,545		
N	R.240	R.260			.798	. 798	. 798		
X	0.040	0.060		1250	.250	1256	. 250		
Y	0.100	0.120		-060	.060	.066	,060		
				166	.100	.100	.100		
A	R1.125	R1.145		1.140	1 1115				
В	R.490	R.510	<u>-</u>		1-146	1440	1.140		
С	0.615	0.635		. 500	.500	. 500	.500		
D	0.240	0.260		1625	,625	.625	,625		
E	1.810	1.830		-245	-245	1245	-248		
F	0.240	0.260		1.820	1.820	1.820	1.820		
G	0.140	0.160		-250	.250	.250	. 250		
Н	0.140-	0.160		1152	152	-152	.152		
	0.140	0.160		. 147		. 147	.147		
		0.100		155		~ 155	.155		
		<del></del>		<del></del>					
	Accent	/Reject							

Measured by:	
Date: 10 - 6 · 2 2	Audited by DT
5410. 7 5 6 22	Date: 10/06/23
Rev Date Change	10/00/23

L	Rev	Date	Change	<u>.                                     </u>	
	Α.	06.09.26	New Issue	Revised by	Approved
	В	08.10.07	Dimension H removed	KJ/EC	
L	С	08.11.28	Dimension 'M' revised	KJ/DD	
			and the field of t	KJ/EC	N

Dart Ae	rospac	e Ltd	,							٠,			
W/O:				V	VORK ORDE	R CHANGES	<u> </u>						
DATE	STEP		PRO				Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect			
Part No	);		PAR #:	Fault Ca	itegory:		NCR: Yes	No DQA:	Date:				
		esolutio			tion:								
NCR:			V	VORK OR	DER NON-C	ONFORMAN	ICE (NCR	)					
DATE	STEP		Description of NC		Corrective A			Verification	Approval	Approva			
DAIL	JILF		Section A	Initial Chief Eng	Action C	<b>Description</b> nief Eng	Sign & Date			QC Inspect			
										,			
							·						

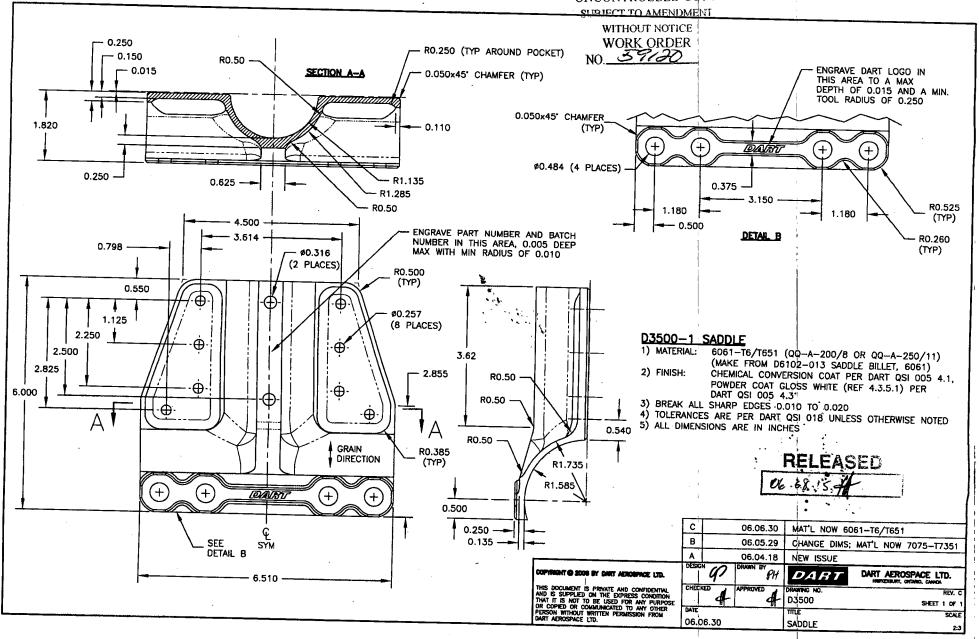
DART AEROSPACE LTD	Work Order:	59120
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page / of 1

				D			······································	<del></del>	
	T			T Re	corded Act	ual Dimens	mensions		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
A	0.483	0.490		. 485	1485	1485	-485		
В	1.175	1.185		1.180	1.180	1.180	1.180	<del>  </del>	
С	3.145	3.155		3-150	3,150	3,150	3.150	┼──┼	
D	1.175	1.185		11180	1.180			+-+	
Ε	0.365	0.385		, 375	- 375	- 37 S			
F	0.490	0.510		- 560	200	.500		<del>                                     </del>	
Н						300	-500		
!	R1.575	R1.595		1,590	1.590	1.590	1.590		
J	0.240	0.260		1245	- 245	- 245		-	<del></del>
K	0.490	0.510		1502	-502	. 502	-245		
<u>      L                              </u>	3.590	3.650		3-625	3-625	3.625	3-625		<del></del>
M	0.315	0.322		- 326	-320	-320	. 320		
N	0.256	0.262		- 258	1258	. 250	- 258		
0	6.500	6.520		6.510	6.50	6.5/0	6.510		
Р	5.990	6.010		6,000	6-000	6-000	6.000		
Q	2.820	2.830		2-823	2.823	2.823	2.823		
R	2.495	2.505		2.498	2.498	2.498	2.498		
S	2.245	2.255		2.250	2.250	2.250	2,250		···
T	1.120	1.130		11125	1.125	1-1250	1.125		
U	0.540	0.560		.845	-545	. 545	.545		
V	0.793	0.803		.798	-788	.798	.798		
W	R.240	R.260		,250	-250	- 250	-250		
X	0.040	0.060		.066	. 060	.000	1060		
Υ	0.100	0.120		,100	1100	100	.100		
				-		7:-0			
AA	R1.125	R1.145		1,140	11/46	1-140	1.140		
AB	R.490	R.510		,500	.500	. 500	-500		·
AC	0.615	0.635		425	-625	-625	.625		
AD	0.240	0.260			-245		,245		<del></del>
AE	1.810	1.830		1.820	1,820	1.820	1.820		
AF	0.240	0.260		. 250	, 250	-250	,250		
AG	0.140			1152	.152		152		
AH	0.140	0.160		147	-147		- 147	<del></del>	
Al	0.140	0.160		155	.155	.155	-155		
	Accon	t/Reject							
	vcceh	Welect							

Management	
Measured by:	Audited by The
Date: 10.6.23	
Date. 12 6 25	Date: 6/06/23
	Date. 6/06/23

ı	Rev	Date	Change		
	A	06.09.26	New Issue	Revised by	Approved
-	В	·	Dimension H removed	KJ/EC	
t	C		Dimension (Afficient	KJ/DD	
L		00.11.20	Dimension 'M' revised	KJ/EC	N/

SHOP COPY
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UNCONTROLLED COPY



## Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval Approval** DATE STEP PROCEDURE CHANGE Bv Chief Eng / Prod Mgr Date **d**tv QC Inspector Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: Date: \_\_\_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_ QA: N/C Closed: \_\_ Date: WORK ORDER NON-CONFORMANCE (NCR) NCR:

NCh:			, 01111 011	BEN NON COM CHIMAIN	3L (11311)				
		Description of NC		Corrective Action Section B	Verification	A			
DATE	STEP	Section A	Initial Chief, Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
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